

METAL CASTING CORE ASSEMBLY FOR CASTING A CRANKSHAFT

Abstract

A core box assembly for casting a crankshaft. The core box assembly comprises axially aligned cores that define different axial portions of a cavity that receives molten metal to cast the crankshaft. Oil gallery cores are placed in the core box assembly to form as-cast oil galleries in the crankshaft. Heavy metal inserts are held by sand cores disposed in the portions of the cavity that form the counterweights of the crankshaft.